

Work Order ID 69907

Tuesday, May 24, 2011 12:59:17 PM



Page 1

Item ID: D2530

Accept



Setup Start



Revision ID:

Stop



Item Name: Handle Weldment

Start Date: 5/24/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2530	Rev B

100 0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut to length as per Dwg D2536
2-Deburr

110



QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

120



Weld per dwg A/R S.S. rod Batch: 115528

0.00

Small Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

8X Ø M 11/05/25

PL 11-05-31

PL 11-06-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

11.06.03 (8)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8.06.01

(8)

150



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:40
320 °F
8:10

8X Ø M-11/06/03

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Required Date: 5/31/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

8 BL 11-6-3.

170



Packaging

Packaging

Identify as per dwg & Stock Location: SOG

Memo

0.00

0.00

11/6/13 SP 80

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

11/6/13 JF
C21106106

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 69907

Parent Item: D2530

Parent Item Name: Handle Weldment

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F
11.01.07 chg qc 5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.750W.049

Purchased

No

100

f

259.0086

2.9145

24.54316



304 RD Tube .750 x .049W

M 117797



M-1 11/05/25
24-54316

Location

Loc Qty

Loc Code

MAT017

259.00863

109314

9.333

111619

3

112187

4

112800

11

114852

2.75

116108

3

116720

1.833

117030

3.09263

117598

21

117795

200

D2534

Manufactured

No

120

Each

12.0000

2

16



Lock Plate



PC 11.05.31

Location

Loc Qty

Loc Code

WA019

12

66807

12

(12)

B69938 → (4)

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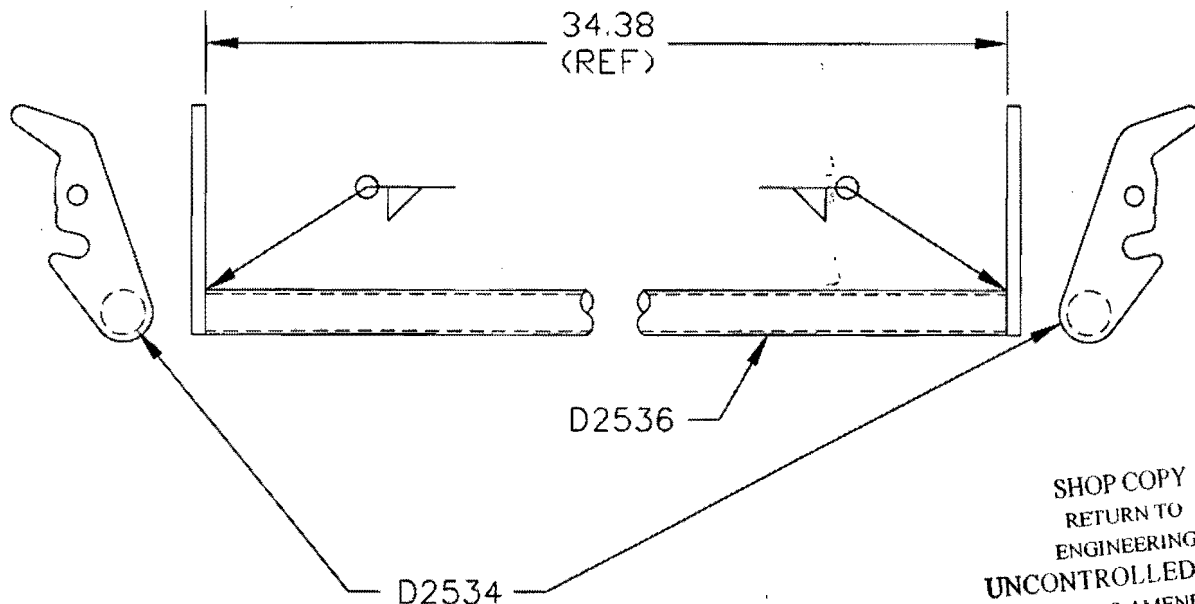
DESIGN		DRAWN BY		DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS		PH			
CHECKED		APPROVED		DRAWING NO. D2530	REV. B SHEET 1 OF 1
DATE 04.12.14				TITLE HANDLE WELDMENT SCALE	
A	96.06.18		NEW ISSUE		
B	04.12.14		UPDATE NOTES AND DIMENSIONS		

RELEASED

04.12.16 *[Signature]*

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69907

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

[Signature] 11-05-24

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